

Date: Thursday, 22/05/2008 1:41:13 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG
Job Number :	39404		
Estimate Number :	10256		
P.O. Number :		Part Number :	D22303
This Issue :	22/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2230 REV F
First Issue :	/ /	Project Number :	N/A
Previous Run :	38919	Drawing Revision :	F
		Material :	
Written By :		Due Date :	06/06/2008
Checked & Approved By :	Qty: 200 Um: Each		
Comment :	Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: 33310

cut @ meter

2.0	BAND SAW	BAND SAW
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**Comment:** Band Saw

Cut D2423 extrusion to 0.82"

Batch:

cut @ meter

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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RG



Issue P/O: 4623 meter



(200)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

machine pending.

D2230 REV. F

4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE
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RG



Rec'd + inspect for transit damage. ensure cof attached.

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------

QCS

**Comment:** SECOND CHECK

inspect levels

20866117

coated

(200)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/05/2008 1:41:13 PM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 39404

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

2/1A S08/06/17

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

200X
M-1 08/06/18

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/06/18 (+200)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

11:45

OVEN TEMPERATURE:

315

FINISH TIME:

11:45

F2/212 08/06/19

M167925

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

08.06.19 X

2/1

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 476

8/6/23

200X

sq

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/23

Job Completion



MF 08-06-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

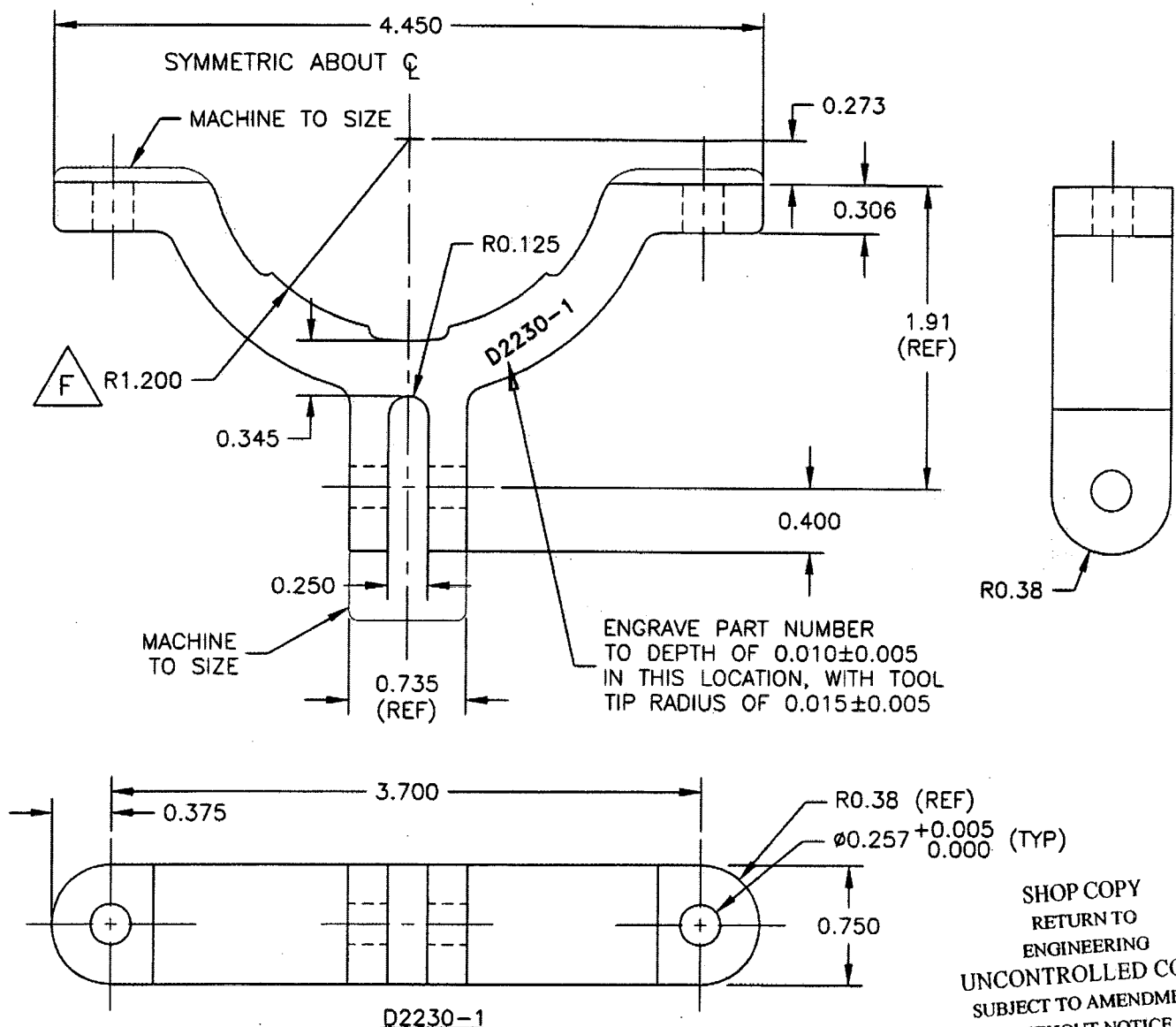
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230
				REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS

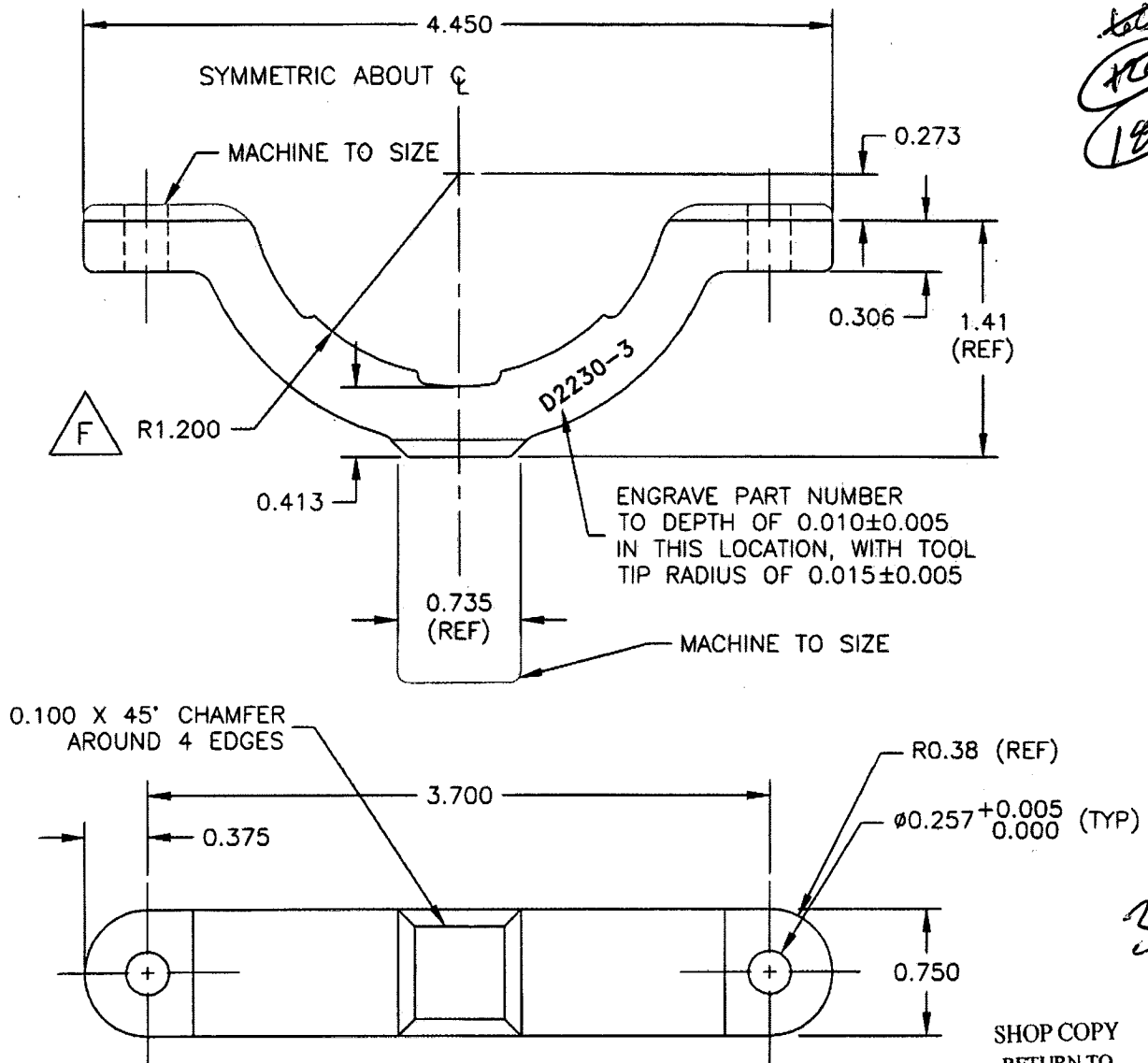


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39401

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
49.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39404



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-3

Lug B39404

MATERIAL: supplied by DART D2423 B33310

6423

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Denise Robinson", with a long horizontal line extending to the right.

Denise Robinson

Vankleek Hill, June 16, 2008